

Date: Wednesday, 1/11/2006 4:25:13 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 25453		
Estimate Number	: 10626		
P.O. Number	: N/A	Part Number	: D30801
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: D3080 REV: A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/30/2006
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	200 Um: Each
Comment	: Est: A 02.10.11 New issue KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 374

Email or ship DXF file to vendor

Laser cut as per Dwg D3080 flat pattern D3080-1

Material release note required

u 06.01.12 200

2.0

D30801B

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s)

Clamp

u 06.03.12

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

u 06/02/12 200

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect per template D3080T1

Jance

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Bend as per Dwg D3080

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 06/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:25:13 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 25453

Part Number: D30801

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.03.08

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble SAs

06.03.08

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

S7122

06/3/13

200

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.03.13

Job Completion



06.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

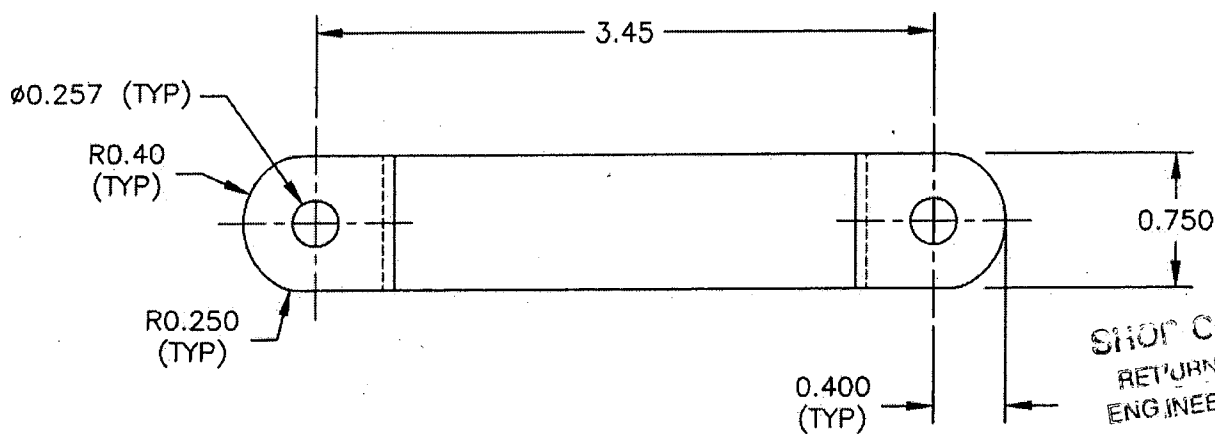
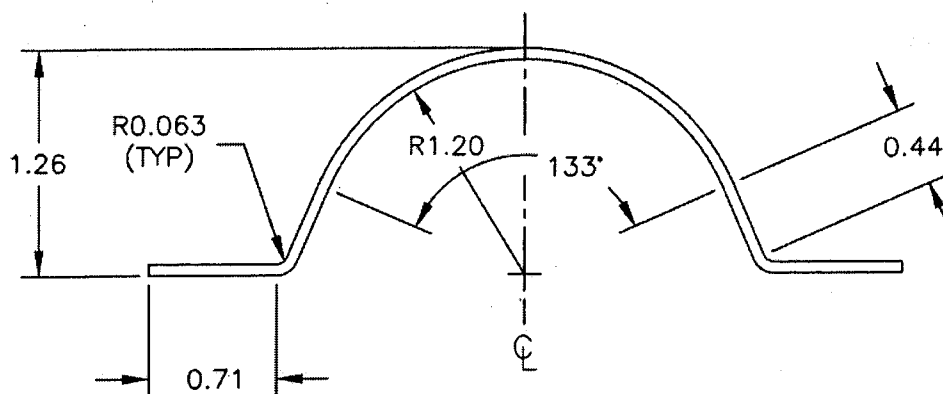
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3080	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE CLAMP	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.2011



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO  
WITH-HOLDING  
WORK  
NO. 25453

#### D3080-1 CLAMP

- 1) MATERIAL: AISI 304/316 SS ANNEALED SHEET 0.063 THICK (REF. DART SPEC M304S16GA)
- 2) FLAT LENGTH: 5.367 END-TO-END  
4.567 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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**CERTIFICATE OF COMPLIANCE**  
**CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 2 OUR JOB NO J0138127 SHIPPING MEMO 0330112

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>200 PCS</u>	<u>PO00000374</u>	<u>D3080-1</u>	<u>A</u>	<u>CLAMP</u>	<u>A</u>	

MATERIAL S.S.T 304 SUPPLIED BY SAMUEL SPECIALTY MAT. REL. NO. 67956 ATT'D

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 02 FEBRUARY 2006

G.F.I. Q.C. REP.

*Dalton H. [Signature]*



*06.02.06*



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

### LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 3 JANVIER 2006

Company Name: G.F.I. Division of Thomas & Betts limited  
Address: 180 avenue Labrosse  
City: Pointe Claire, Qué.  
Zip Code: H9R 1A1

# du client: 67956

# de commande SSMQ: 849325

Customer's order #:

SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
4	33	.060" X 48" X 96"	304 2B		7251138
4	7	.060" X 48" X 96"	304 2B		7251304

Bien à vous,  
Yours truly,

Commis à l'administration.  
Administration Clerk.



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Rockport Works**  
**Rockport, IN 47635**

Page 1

Load No. 7615612  
 SRN No. 7615612

CUSTOMER REFERENCE	SAMUEL SON & CO., LIMITED PUR DEPT STAINLESS STEEL 2360 DIXIE ROAD MISSISSAUGA, ON L4Y 1Z7	SHIP TO	SAMUEL 2360 DIXIE RD MISSISSAUGA, ON, CN L4Y 1Z7	MILL ORDER NO. 241851-1648	PROCESSOR ORDER NO. S15826-8	BUYERS ORDER NO. S15826-8
	PART NO. 7219.339011		ENGLISH UNITS - PRODUCT - METRIC UNITS .0600 NOM 48.0000 X COIL			

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID
625766-01B	1	7251138	0625766-01	18,250 LBS. 8,278 KG.	444940902
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT	
1	1			18,250 LBS. 8,278 KG.	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

**CHEMICAL ANALYSIS**

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7251138	.051	1.397	.028	.0039	.354	18.16	8.08	.30	.0400	.29						

SHIPPING DATE: 10/06/2005

REMARKS:

NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE  
 MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL  
 MATERIAL FREE OF RADIOACTIVE ISOTOPES

**PRODUCT DESCRIPTION**

CR SHI TYPE 304 STAINLESS #2B FINISH SLIT EDGE TEST REPORTS \* ASTM A 240 -04 EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8  
 \* ASTM A 480 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY \* ASM  
 E SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 ED APPLY \* ASME SA-480 S  
 ECTION II PART A (2004 ED)

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front			
0625766-01	T	T	A.S.T.M	57.7	95.8	45.2	B 85.0	B 84.0			
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	BEND 180 IT							
0625766-01	T		A.S.T.M	OK							

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT  
 AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MWOC#0049 3/99

SIGNED

*[Signature]*  
 QUALITY MANAGER

DATE 10/07/2005 TIME 05:46 AM

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK  
 Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A  
 THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"



